












Date: Thursday, 07/08/2008 4:20:37 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RAPPEL ANCHOR
Job Number	: 41052	Part Number	: D2224
Estimate Number	: 11069	Drawing Number	: D2224 REV E
P.O. Number	:	Project Number	: N/A
This Issue	: 07/08/2008 S.O. No. :	Drawing Revision	: E
Prsht Rev.	: NC	Material	:
First Issue	: // Type : MACHINED PARTS	Due Date	: 30/08/2008
Previous Run	: 40891	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	JULIE LECOCQ 08.08.08		
Comment	Est Rev:D 02.04.23 Add note for grain direction & inspect 8, 21 N G		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M7075T73B2500X0325	7075-T73 Bar 2.50 x 3.25	
			
Comment: Qty.: 0.2321 f(s)/Unit Total: 1.1603 f(s) Not exacte Material 7075-T73 Bar 2.5 x 3.25 3.5 (M7075T7B0325X0320) Batch: 41052 M107955 mmf 08/08/31			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blanks: 2.660" +.030" / -.010" *****Note grain direction ***** mmf 08/08/31			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio D2224 & Dwg D2224 2-Deburr & Tumble N.A 08/09/18			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE N.A 08/09/18			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK 28/08/09/20			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: RAPPEL ANCHOR

Job Number: 41052

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7214

C 08/09/22

(10)

Red Anodize as per Dwg D2224 MIL-A-8625

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

P 8/9/25 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

S 08/09/06 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 21

8/9/26

(10)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41052
Description: Rappel Anchor		Part Number: D2224
Inspection Dwg: D2224	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	+/-0.010	0.188	✓			
0.050 x 45°	+/-0.010 x 0.5°	0.0498	✓			
0.250	+/-0.010	0.249	✓			
R0.500	+/-0.010	R0.500	✓			
3.000	+/-0.010	3.001	✓			
Ø0.507	+0.008/-0.001	Ø0.5085	✓			
0.750	+/-0.010	0.746	✓			
2.313	+/-0.010	2.310	✓			
1.687	+/-0.010	1.687	✓			
2.438	+/-0.010	2.438	✓			
1.125	+/-0.010	1.126	✓			
Ø0.313	+0.006/-0.001	Ø0.314	✓			

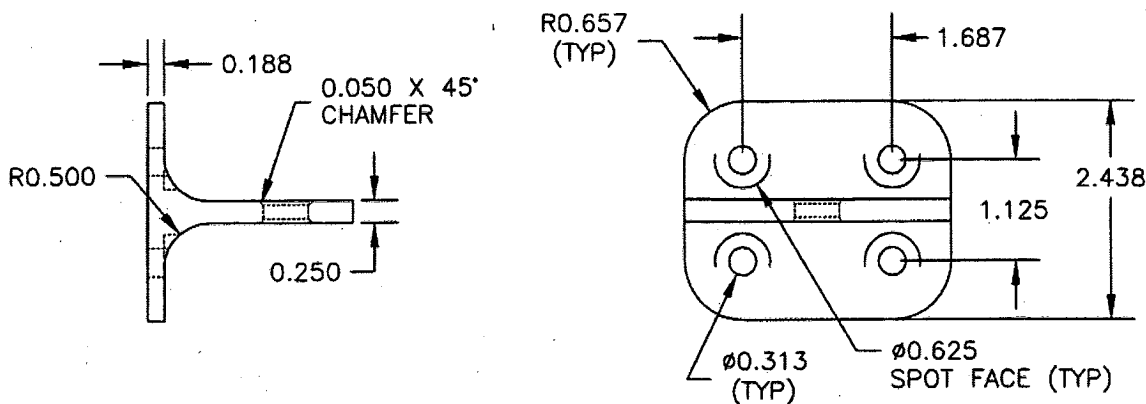
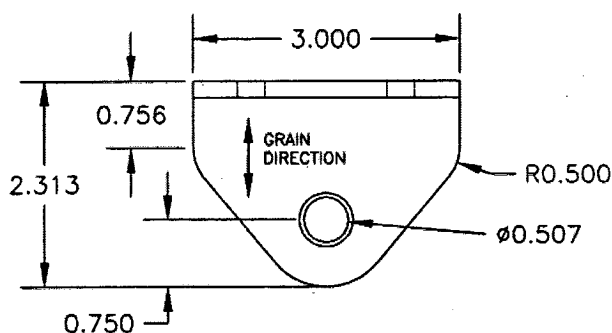
Measured by: G.A.	Audited by: SP	Prototype Approval:	N/A
Date: 08/09/19	Date: 08/09/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	AS



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED
99.05.11 KE



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41052



TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

68408

24-Sep-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 7214
PURCHASE ORDER/**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	10	10	D2224 B41052 -	RED ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2
2	14	14	D3299-1 B41828 -	BLUE ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

S
09/09/26

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

